












Date: Thursday, 02/10/2008 10:35:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 42418	
Estimate Number : 13309	
P.O. Number :	Part Number : D37911
This Issue : 02/10/2008 S.O. No. :	Drawing Number : D3791 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 39694	Material :
Written By :	Due Date : 10/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 08.10.02</u>	
Comment : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S16GA 304/316 Sheet .063
	 
Comment: Qty.: 0.3063 sf(s)/Unit Total: 6.1257 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>109057</u> <u>IB 8-10-6</u> <u>IB 8-10-7</u>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D3791 Dwg Rev: <u>A</u> <u>IB 8-10-6</u> <u>IB 8-10-7</u> Prog Rev: <u>A</u> 2-Deburr if necessary <u>IB 8-10-6</u> <u>IB 8-10-7</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	 
Comment: SECOND CHECK <u>508/10/02</u> <u>(+25)</u>	
5.0	BRAKE NC NC BRAKE
	 
Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs <u>CP 08/10/10</u> <u>(25)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3791-1 PAR #: N/A Fault Category: Prod/Ins. Ass. med Small NCR: (Yes) No DQA: D Date: 08/16/16
 Resolution: Scrap Disposition: QA: N/C Closed: D Date: 08/16/16

NCR: <u>42418</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.06	3	Parts adjust of tolerance R.C. employee lowered his Set offset after noticing that all his hole size were close to the highest tol.	<u>AS</u> <u>QSE 042</u> <u>08.09.06</u> <u>10</u>	Recommend scrap b/c parts from waterjet are out of tolerance and not the same each time.	<u>B</u> <u>8-10-7</u>	<u>S</u> <u>08/10/07</u>	<u>AS</u> <u>08.10.06</u> <u>QSE</u> <u>042</u>	<u>S</u> <u>8/10/06</u>
				- Remind employee that hole size are ok to be at the top of the tol.				<u>S</u> <u>8/10/06</u>

NOTE: Date & initial all entries

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Part Number: D37911

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

S 68/10/15 (25)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M109303

FL 8-10-15 (25)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/15 (25)

9.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

S 08/10/15 (25)

10.0

POWDER COATING

POWDER COATING



M 106442



(25X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
322 OF
9:50

M 08/10/15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(25)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/15

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(25)

Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker and Stock

Location: FP-17

FL 08/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D37911

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/16 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 28.10.15

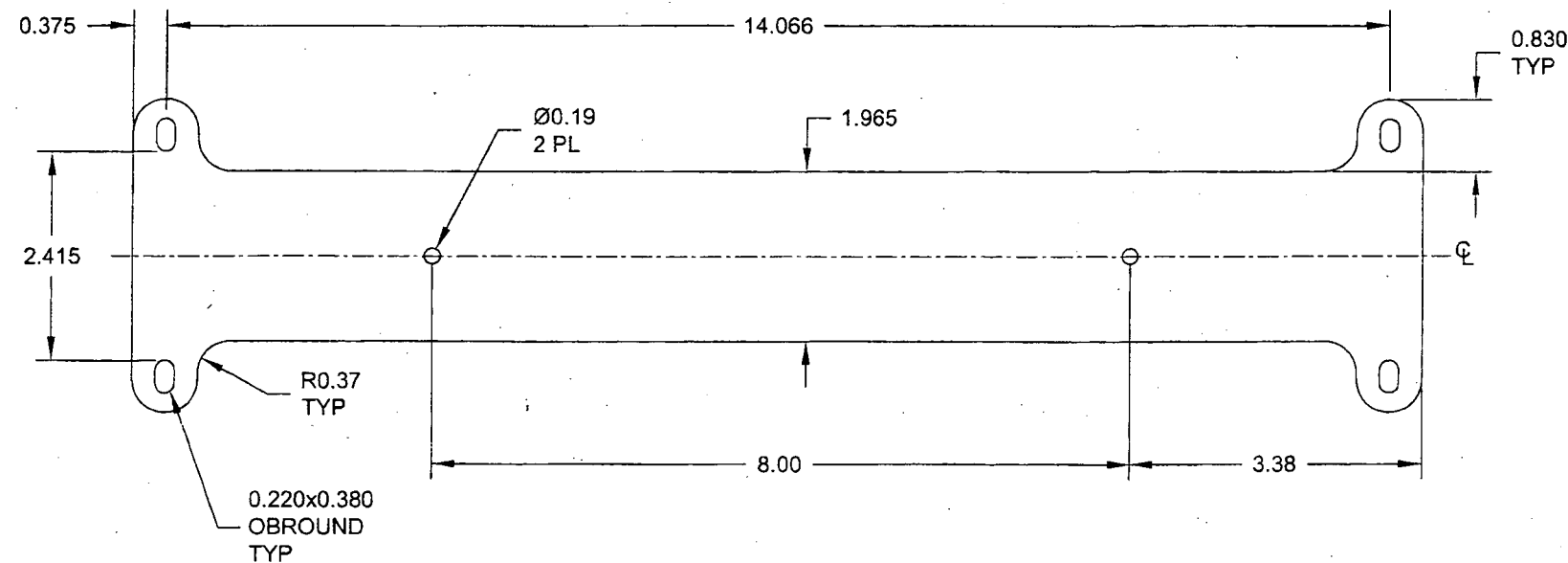
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

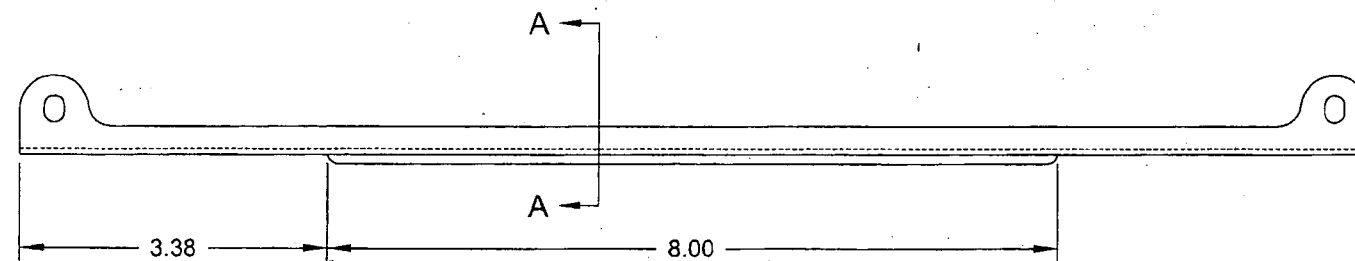
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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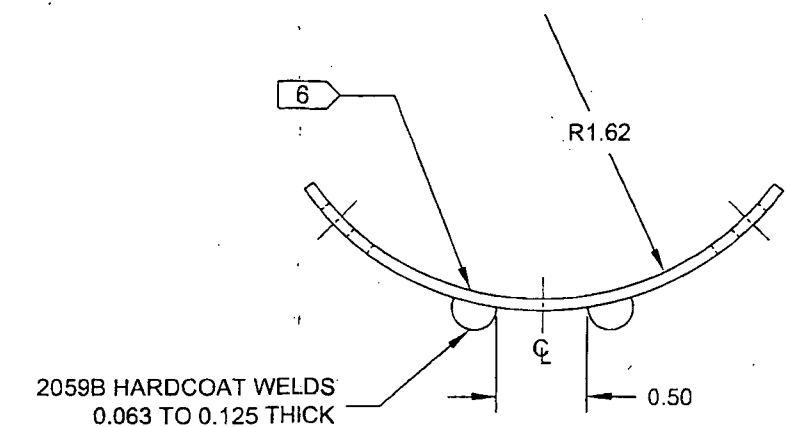
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

RELEASED
08.05.13
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42418

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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